

Work Order ID 124706-25PLIT

124706

Page 1

Monday, September 22, 2014 1:57:15 PM

Item ID: 647.1701 Accept *N900040100* Setup Start *NS1*
 Revision ID:
 Item Name: Skid Deflector Assembly Stop *NS2*
 Start Date: 9/22/2014 Start Qty: 2.00 *2* 1 Cust Item ID:
 Required Date: 9/22/2014 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MJS Date: 14-09-22 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.1700	C								

110 Pick Kit 0.00

110

Packaging Memo 0.00
 Packaging

120 0.00

120

Small Fab Memo 0.00

Small Fab
 1- Assemble item 4,6,7 and 8 as per dwg.
 2- Clamp item 1 and 2 to item 3. Transfer drill holes as per dwg see note 6. Use clecos.
 3- Disassemble parts
 4- Deburr
 5- Touch up expose aluminum with alodine
 6- Re-assemble as per dwg.

BIS/07/07
 PTO →
 N/A

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Page 2

Item ID: 647.1701

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skid Deflector Assembly

Start Date: 9/22/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

JUL 09 2015
AS
38
9-89

170

0.00

170

SprayPaint

Memo

0.00

Spray Painting

***TOUCH UP WITH PRIMER ***

PRIMER BATCH: 131277

DAS
41
9-89
15-7-14

180

QC14- Inspect Spray Paint

0.00

180

QC

Memo

0.00

Quality Control

DAS
9
9-89
15-07-17

Work Order ID 124706

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Page 3

Item ID: 647.1701 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Skid Deflector Assembly Stop *NS2*

Start Date: 9/22/2014 Start Qty: 2.00 *2*

Required Date: 9/22/2014 Req'd Qty: 2.00 *2*

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>CC F0114</u>	0.00							
210									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

DAS
9-89

JUL 19 2015

MLJ

JUL 20 2015

MLJ

JUL 20 2015

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124706

647 1701

Required Date: 9/22/2014

Required Qty: 2.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.1710 *647 1710* Plate		Manufactured	No				Each	18.0000		2		DAS 41 9-89 14-11-30	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF				18					
				91798				10					
				93277				8		2			
647.1711 *647 1711* Plate		Manufactured	No				Each	18.0000		2		DAS 41 9-89 14-11-30	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF				18					
				91799				10					
				93413				8		2			
647.1712 *647 1712* Gusset		Manufactured	No				Each	9.0000		2		DAS 41 9-89 14-11-30	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF				9					
				93308				2					
				93801				5					
				98683				2					

Picklist Print

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Work Order ID: 124706

124706

Parent Item: 647.1701

647 1701

Parent Item Name: Skid Deflector Assembly

Start Date: 9/22/2014

Required Date: 9/22/2014

Start Qty: 2.00

Required Qty: 2.00

647.1713 Manufactured No

Each 69.0000 2

DAS

647 1713

41
9-89 14-11-30

Spacer

Location	Loc Qty	Loc Code
CCK107	69	
104845	40	
91801	6	
92561	2	
93408	12	
99057	9	

CR3213-4-4 Purchased No

Each 1,114.000 44

DAS

CR3213-4-4

41
9-89 14-11-30

Rivet

Location	Loc Qty	Loc Code
ST320	1114	
123185	14	
126282	500	
M128401	400	
M128813	200	

22 ~~30~~ 15/07/07

NAS1149F0332P Purchased No

Each 4,253.000 4

DAS

NAS1149F0332P

41
9-89 14-11-30

Washer

Location	Loc Qty	Loc Code
ST275	4253	
122063	205	
123900	10	
125646	106	
m127831	1932	
m130325	2000	

4

Picklist Print

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124706

Parent Item: 647.1701

647 1701

Parent Item Name: Skid Deflector Assembly

Start Date: 9/22/2014

Required Date: 9/22/2014

Start Qty: 2.00

Required Qty: 2.00

MS21042-3 MS21042L3 Purchased No

Each 1,369.000 2

DAS

41

9-89 14-11-30

MS21042-3

**

Nut

Location

Loc Qty

Loc Code

CA	295
M129682	295
ST307	1074
123185	5
123352	31
M123525	9
M128770	929
M129541	100

2

MS27039-1-14 Purchased No

Each 877.0000 2

DAS

41

9-89 14-11-30

MS27039-1-14

**

Screw

Location

Loc Qty

Loc Code

GA	98
120449	98
ST506	214
124326	214
st507	565
124326	565

2

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 04058

SHEET 1 OF 1

DWG NO. 647.1700

REV: B

PREPARED
BY

D. PETERS

DATE: 08/14/13

EFFECT ON DWG
☒ INC. ☐ UNINC.

DWG TITLE: SKID DEFLECTOR ASSY

APPROVED BY

ENGR

MFG

QC

EFF

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: MARKED INSPECTION DIMENSIONS

ECR

NONE

UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124706 MJS

14 09-22

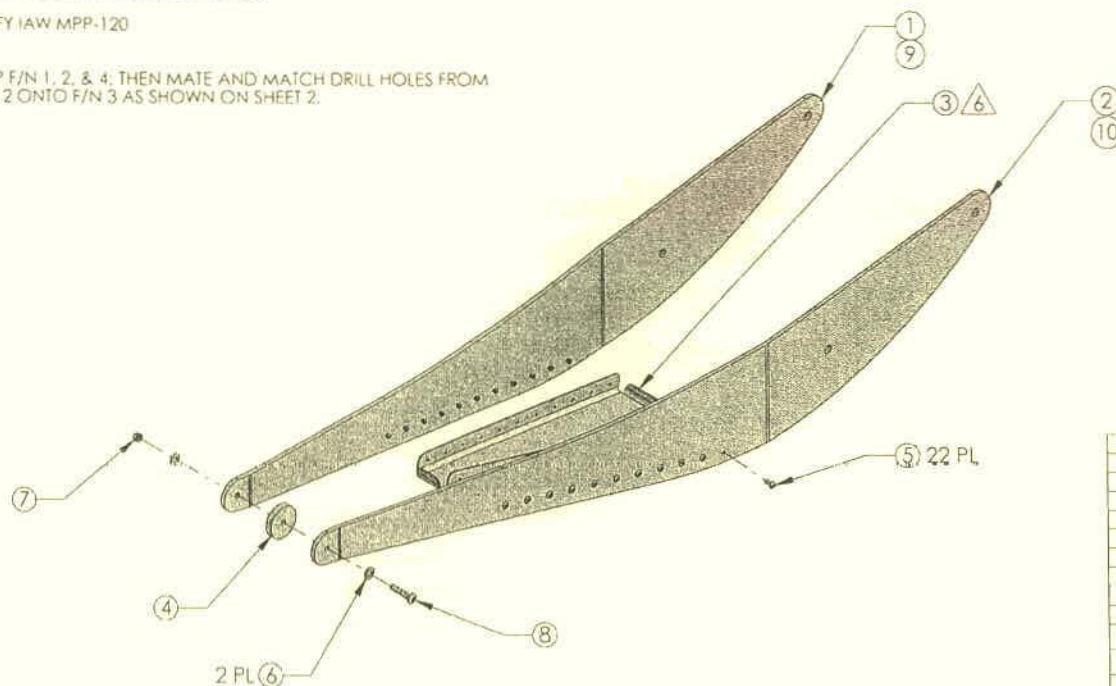
DOCUMENTS EFFECTED: ☐ RFMS ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

NOTES:

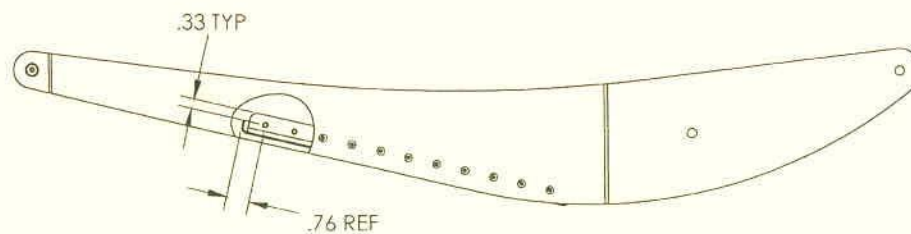
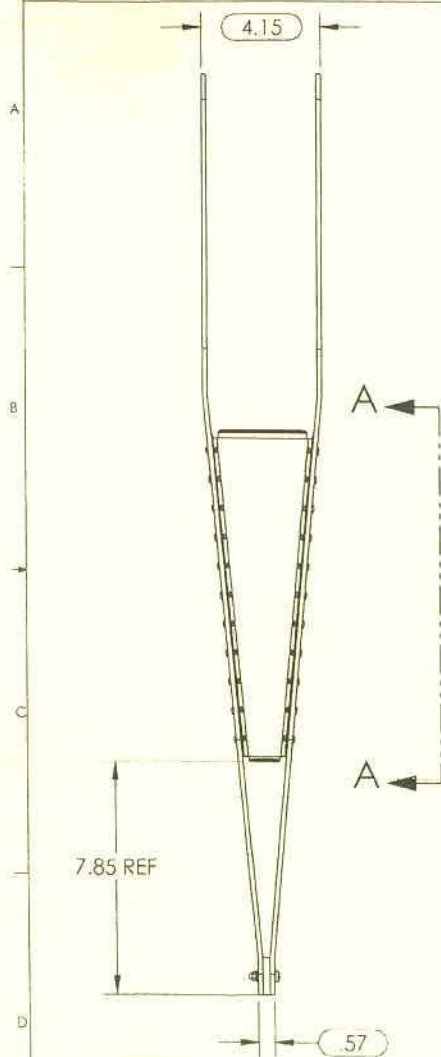
1. MATERIAL: 7075-T6 ALUMINUM PER AMS-QQ-A-250/12
2. MATERIAL: 6061-T6 ALUMINUM BAR IAW AMS-QQ-A-250/11
3. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER, COLOR BLUE;
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
4. DEBURR AND BREAK ALL SHARP EDGES
5. IDENTIFY IAW MPP-120
6. CLAMP F/N 1, 2, & 4; THEN MATE AND MATCH DRILL HOLES FROM
F/N 1 & 2 ONTO F/N 3 AS SHOWN ON SHEET 2.



REVISION			
REV	DESCRIPTION	DATE	APPROVED
	LAST PROJECT REVISION PRI		100
100	BATH, REBATH	20/05/08	P. BRAVO
A	INCORPORATED E.C. 1 (243) & 032	20/07/13	P. BRAVO
B	INCORPORATED E.C. 031/03	09/11/13	P. BRAVO
C	INCORPORATED E.C. 04050	28/11/15	P. BRAVO

	I		10	647 1215	PLATE		△		△
	I		9	647 1214	PLATE				△
	I	I	8	601 1622	SCREW	M527039-1-14			
	I	I	7	601 2943	LOCKWHL	M521042-3			
	I	2	6	601 1602	WASHER	NAS1149F0332P			
	I	ZZ	S	601 1915	RIVET	CR3213-4-4			
	I		4	647 1213	SPACER				△
	I	I	3	647 1212	GUSSET				△
		I	2	647 1211	PLATE				△
		I	1	647 1210	PLATE				△
X				647 1202	SKID DEFLECTOR ASSY				
	X			647 1201	SKID DEFLECTOR ASSY				
1202	1201	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.			
QTY				PARTS LIST					
NEXT ASSEMBLY(S)				APICAL INDUSTRIES 2628 TEMPLE HEIGHTS DR OCEANSIDE, CA 92056-3312 / (609) 724-5333					
647 1200									
				SKID DEFLECTOR ASSY					
				REV. NO.	CAGE CODE	QTY.	647.1200		
				B	076628				
				SCALE ACROSS			SHEET 1 OF 3		

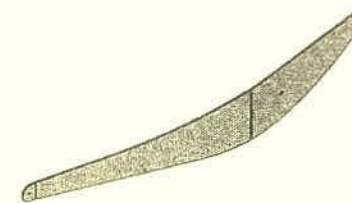
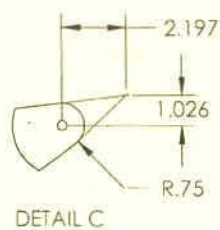
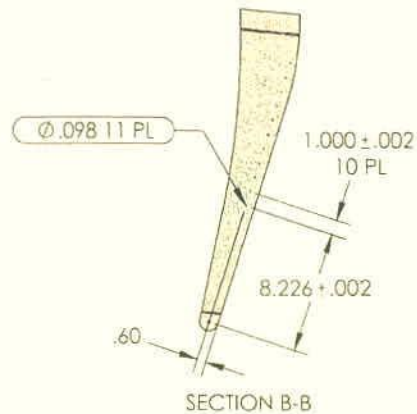
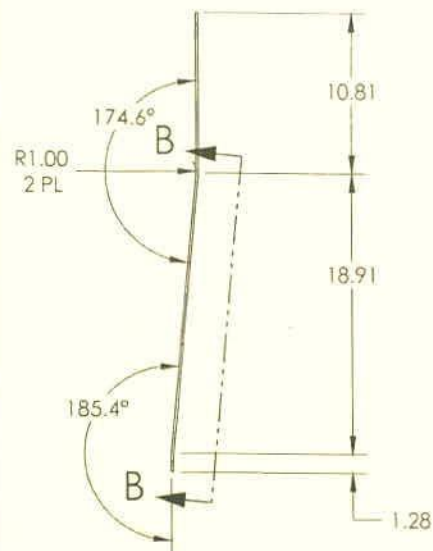
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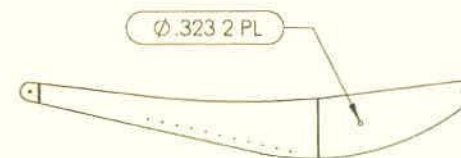
SECTION A-A

APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
SKID DEFLECTOR ASSY	
DATE: 07/20/88 DRAWN BY: [blank] CHECKED BY: [blank] SCALE: NONE	PART NO: 647.1700 REV: C SHEET: 2 OF 2

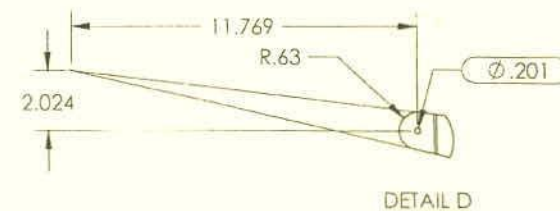
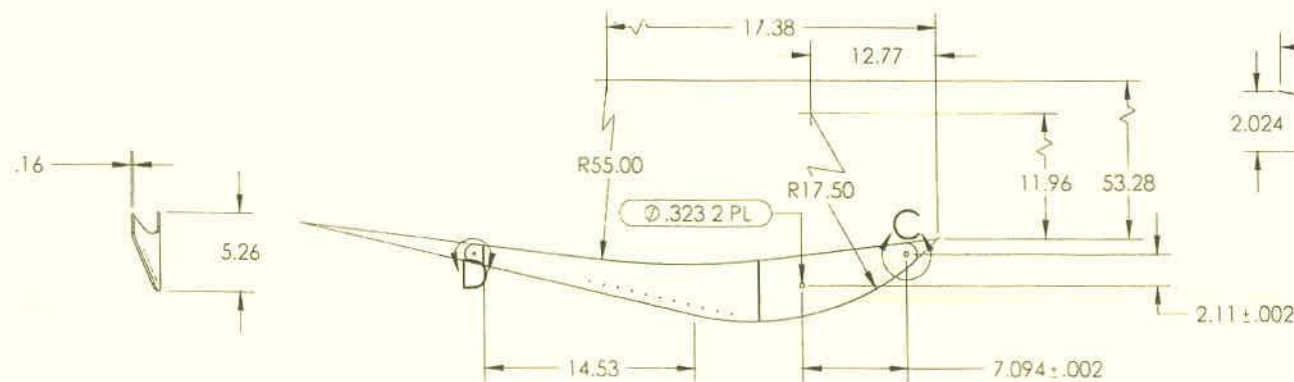
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647.1711 SHOWN
647.1710 OPPOSITE

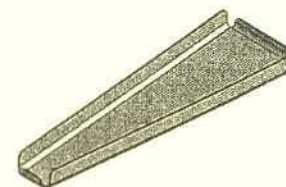
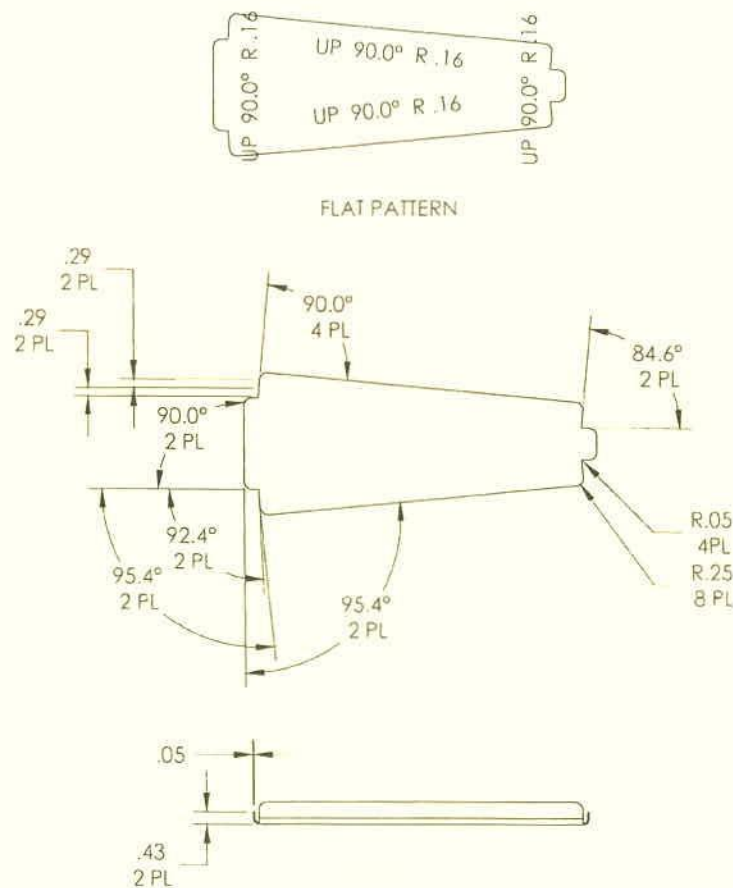
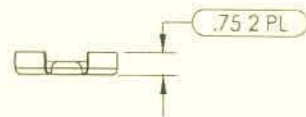
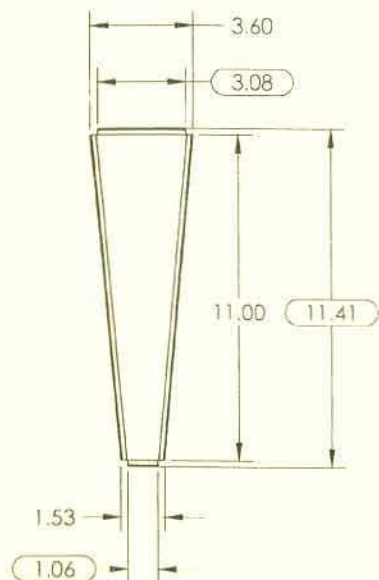


647.1714 SHOWN
647.1715 OPPOSITE



APICAL INDUSTRIES	
2608 TEMPLE HEIGHTS DR.	
OCEANSIDE, CA 92056-3512 (760) 724-5300	
SKID DEFLECTOR ASSY	
REV	DATE
B	07/10/10
SCALE	NONE
SHEET	3 OF 5

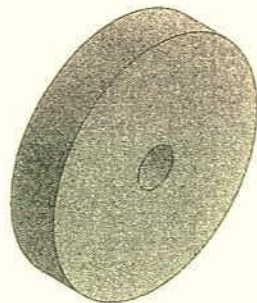
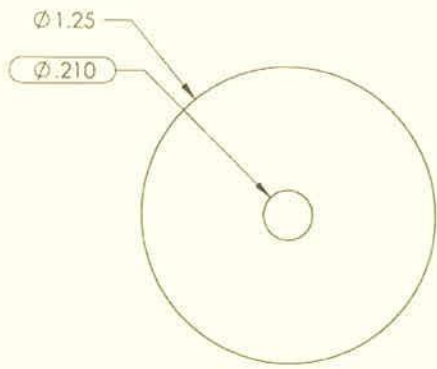
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647.1712

APICAL INDUSTRIES	
2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300	
SKID DEFLECTOR ASSY	
REV	DATE
8	07/06
SCALE: NONE	
SHEET 4 OF 5	

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647.1713

DATE: 01/11/01 DRAWN BY: J. H. H. H. CHECKED BY: J. H. H. H. APPROVED BY: J. H. H. H. COORDINATOR: J. H. H. H.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300	
TITLE: SKID DEFLECTOR ASSY PART NO: 647.1700 SCALE: NONE		SHEET 5 OF 5	